

Date: Tuesday, 5/23/2006 8:36:18 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG
Job Number	: 27204A		
Estimate Number	: 10338		
P.O. Number	: N/A	Part Number	: D2657
This Issue	: 5/23/2006 S.O. No. : N/A	Drawing Number	: D2657 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Drawing Revision	: A
Previous Run	: 26801	Material	: N/A
Written By	: <i>See comment below</i>	Due Date	: 6/10/2006
Checked & Approved By	: <i>J.F. 06.05.23</i>	Qty:	30 Um: Each
Comment	: Est Rev: A New Issue 05-11-07 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010B0750X02500	ASTM A21 Steel .75"x2.5"
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Comment: Qty.: 0.1925 f(s)/Unit Total: 5.7740 f(s)  
 Material: ASTM A36 steel bar 2.50" x 0.75" thick  
 (M1010-B0.750 x 02.500)  
 Batch *M100283*

*J.F. 06/05/25**30*

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW  
 Cut blanks: 2.200" long

*J.F. 06/05/25**30*

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine per folio FA040 and Dwg D2657

2-Deburr

*J.F. 06/05/25**30*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*J.F. 06/05/25**30*

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*MB 06/05/29**30*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_

NOTE: Date & initial all entries

NCR: Yes ☒ No ☐ DQA:  Date: 06/05/31

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST54

16/0/30

(30)

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

16/05/31 (30)

Job Completion



U 06105-31

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

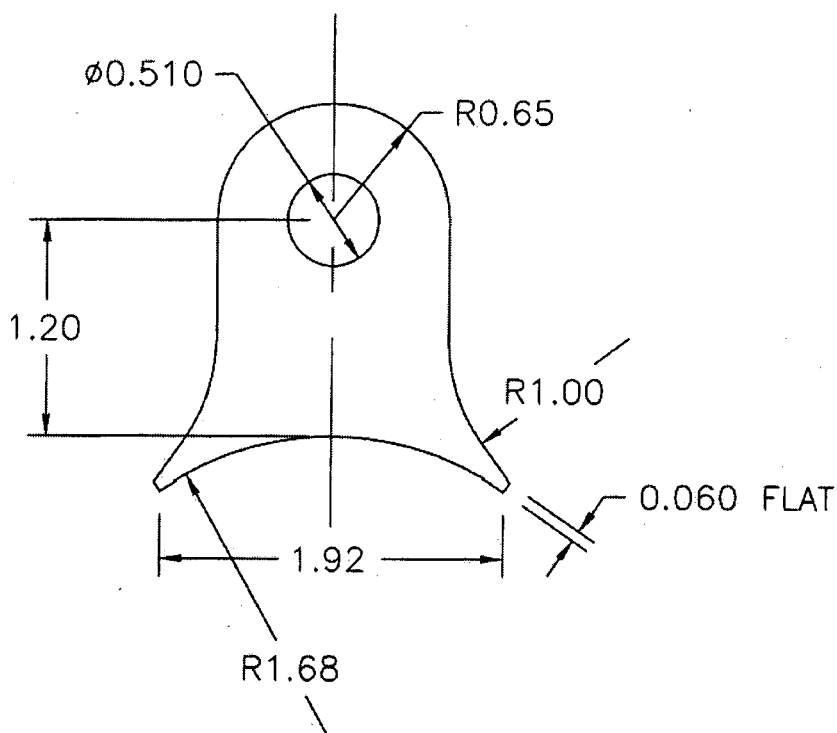
NOTE: Date & initial all entries QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_





DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2657	REV. A SHEET 1 OF 1
DATE 97.11.03		TITLE LUG	SCALE 1:1
A	97.11.03	NEW ISSUE	

RELEASED  
97/11/07 DS



0.063 *00.04.05* *[Signature]*

BREAK ALL SHARP CORNERS ~~0.010 TO 0.020~~  
MATERIAL: ASTM A36 STEEL 0.375 THICK  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
PART IS SYMMETRIC ABOUT CENTER-LINE

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. **27204A**